

Date: Monday, 12/01/2009 2:36:46 PM
 User: Julie Dawson

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	HINGE DOOR PUSH-OUT WINDOW	
Job Number :	44651			
Estimate Number :	13069			
P.O. Number :		Part Number :	D35431	
This Issue :	12/01/2009	S.O. No. :		
Prsht Rev. :	NC	Drawing Number :	D3543 REV.B	
First Issue :	/ /	Project Number :	N/A	
Previous Run :	41812	Drawing Revision :	B	
	Type :	Material :		
	SMALL /MED FAB	Due Date :	02/02/2009	Qty: 6 Um: Each
Written By :				
Checked & Approved By :	JLD 09.01.13			
Comment :	Est Rev:A New issue Rev B dwg 07-11-14 DD verified by:ec			

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	MACRLICS125	1/8" Polycast II Sheet
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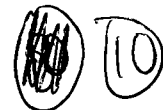
Comment: Qty.: 1.7126 sf(s)/Unit Total: 10.2753 sf(s)
 Polycast II or plexiglass G .125"
 batch: 110115 B 9-4-6

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
 1-Cut as per Dwg D3543
 Dwg Rev: B
 Prog Rev: B

B 9-4-6



2-Deburr if necessary

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

B 9-4-6

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

SUS 6/6 (10)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1
 1-Deburr if necceray
 2-Engrave P/N & B/N as per dwg D3543

Ep 09/04/08 (10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 12/01/2009 2:36:46 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HINGE DOOR PUSH-OUT WINDOW

Job Number: 44651

Part Number: D35431

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/04/08 (f10)

7.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Wrap window in plastic wrap

09/04/13 (10)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 218

9/4/13

(10k)
SC

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/04/13

Job Completion



MF 09-04-13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>B</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>HA</i>	DRAWING NO. D3543	REV. B SHEET 1 OF 2
DATE 06.11.24		TITLE HINGE DOOR PUSH-OUT WINDOW	SCALE 1:4
A	06.08.01	NEW ISSUE	
B	06.11.24	REMOVE D3568-1 PLACARD; D3543-041 ASS'Y NOT REQUIRED ANYMORE	

D3543-1 HINGE PANEL DOOR PUSH-OUT WINDOW

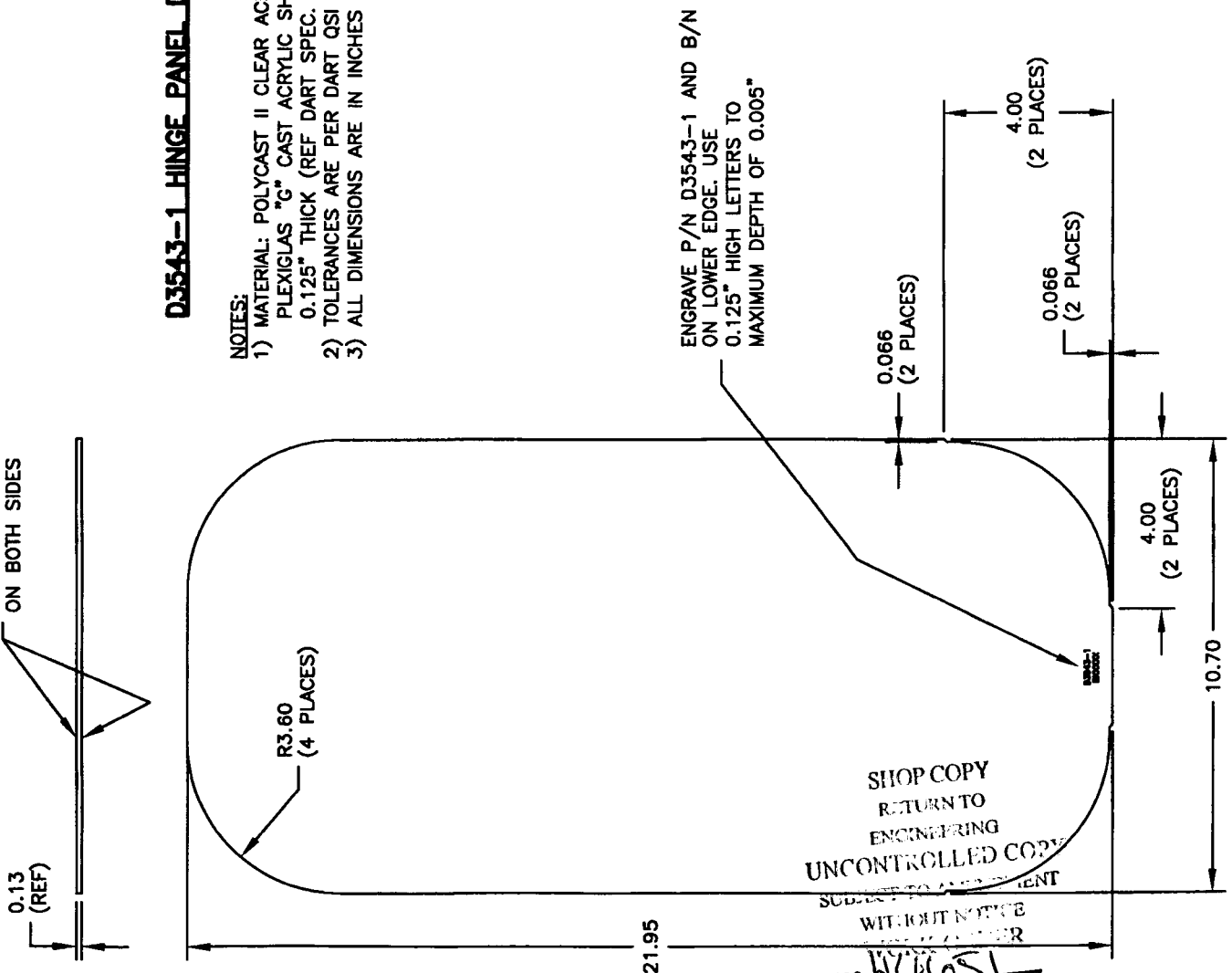
NOTES:

- 1) MATERIAL: POLYCAST II CLEAR ACRYLIC SHEET PER MIL-P-5425 OR PLEXIGLAS "G" CAST ACRYLIC SHEET PER LP-391 TYPE 1 GRADE C, 0.125" THICK (REF DART SPEC. M-ACRYLIC-S.125)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

RELEASED

06.12.12 *HA*

3M MASKING FILM PR-N3213
ON BOTH SIDES



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DESIGN <i>B</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3543	REV. B SHEET 2 OF 2
DATE 06.11.24		TITLE HINGE DOOR PUSH-OUT WINDOW SCALE 1:4	

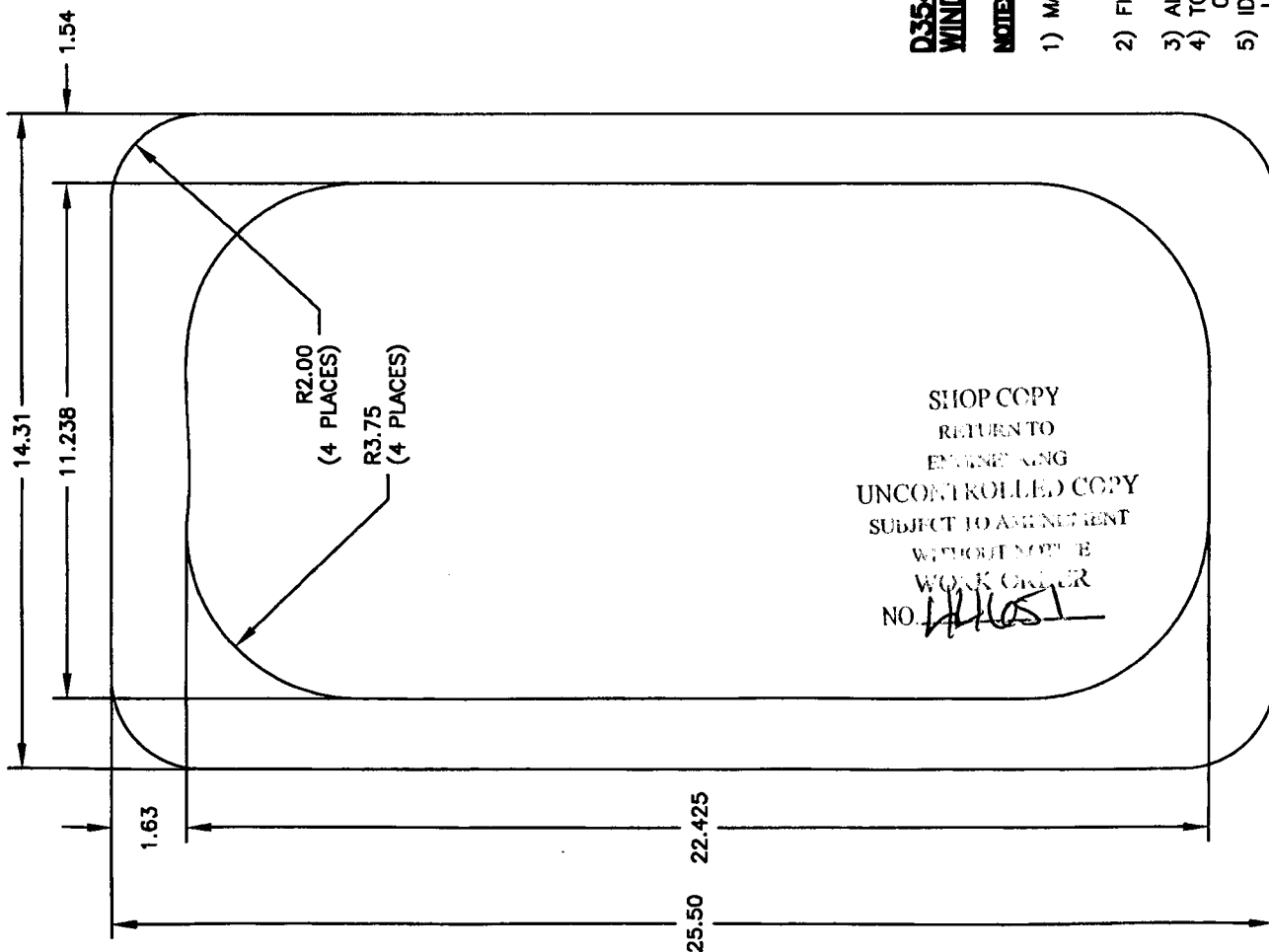
RELEASED

do. 12.12

D3543-3 HINGE DOOR PUSH-OUT WINDOW FRAME

NOTES:

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.063 THICK ALUMINUM SHEET (REF. DART SPEC. M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) IDENTIFY WITH DART P/N D3543-3 & B/N USING FINE POINT PERMANENT MARKER



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